

Date: Wednesday, 9/12/2007 12:13:50 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG ASSEMBLY 206L/407 GHW LUG
Job Number : 34614
Estimate Number : 10318
P.O. Number : N/A Part Number : D2659
This Issue : 9/12/2007 S.O. No. : N/A Drawing Number : D2659 REV A
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS Drawing Revision : A
Previous Run : 34076 Material : N/A
Due Date : 9/30/2007 Qty: 30 Um: Each
Written By :
Checked & Approved By : 02.09.12
Comment : Est: D 02.09.20 Re-format; Incorporated D2657; D2658 KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 34614A LUG



Comment: Sub-Component LUG
D2657 B 34076A

FC 07/09/20 (35)

2.0 34614B LUG BRACKET



Comment: Sub-Component LUG BRACKET
D2658 B 33780A x1 B34484B x1 B3461416 x 31 FC 07/09/20 (35)

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2659 using location Jig DT8484
A/RSteel Rod M1037941

FC 07/09/20 (35)

4.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

FC 07/09/21 (35)

5.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FC 07/09/21 (35) counter

6.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QST 005 4.3

Issue P.O. 4650 Atelier Debosselage FC 07/09/21 (35)
Spray paint Jet Fleet Blue + clear

66 Receive + Inspect for format damage

FC 07/09/24 (35)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/15/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY 206L/407 GHW LUG

Job Number: 34614

Part Number: D2659

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC21

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9.0

QC21

FINAL INSPECTION/W/O RELEASE



35

Comment: FINAL INSPECTION/W/O RELEASE

207109/06

Job Completion



W 07109-26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

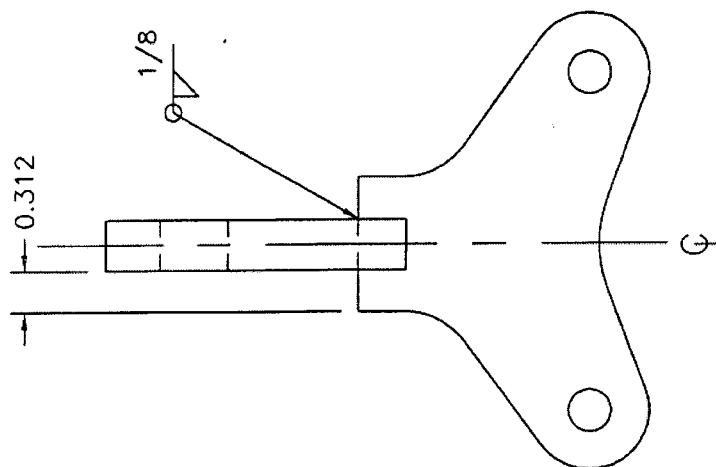
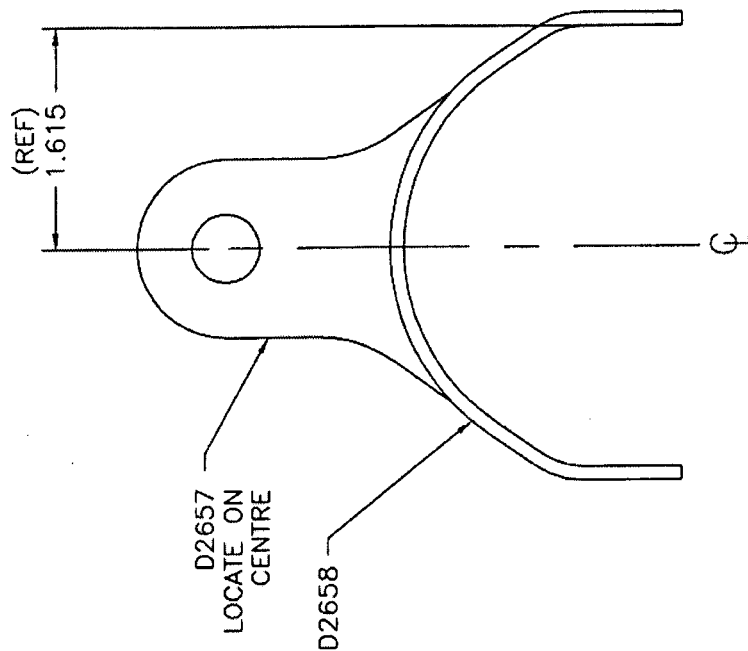
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NOTE: Date & initial all entries



DESIGN <i>DMS</i>	DRAWN BY <i>DMS</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>S</i>	APPROVED <i>U</i>	DRAWING NO. D2659	REV. A SHEET 1 OF 1
DATE 97.11.03		TITLE LUG ASSEMBLY	SCALE NTS
A	97.11.03	NEW ISSUE	

RELEASED
97/11/06 DS



D2659 LUG ASSEMBLY

WELD PER DART QSI 004
FINISH: POWDER COAT PER DART QSI 005 4.4
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
PART IS SYMMETRIC ABOUT CENTRE-LINES (Q)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34614

